

DT8730 -003



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

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D2665-1**Job Sheet 190710****Part No:** D2665-1**Job Qty:** 4 pcs**Part Name:** Saddle, LH Fwd Aft Out**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 2/13/19**Job Tracking No:****Due Date:** 3/18/19**Created By:** Marie Lajeunesse**Type:** Stock**Description:**

Note: DWG REV D IPP: C 00.11.01 Removed P/O for Powder Coat - in house process EC IPP Rev:D As per Rev D 07-03-19 JLM

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	4 pcs	3/18/19		1.75	6.15	HAAS - 1		
							HAAS - 2		
							HAAS - 3		UHG 19/3/29
							HAAS - 4		
110	Conventional Mill - 1 - B4B	4 pcs	3/18/19		0.00	4.00	Conventional Mill - 1 - B4B		UHG 19/3/29
							Conventional Mill - 2 - B4B		
120	QC 2	4 pcs	3/18/19		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		UHG 19/3/29
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		

**Container No:** S167462**Part:** D2665-1**Job No:** 190710**Serial No/Batch:** S167462**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's

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Date: 03/28/19

Plex 2/14/19 9:21 AM Dart.Hadley.Shannon

https://www.plexonline.com/29ce54de-ac48-4670-8118-d1bf9b3279bb/Plexus_Control/Report_View_2.asp?URL=https://www.plexonline.com/29ce5... 2/4

				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 6	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
170	Packaging 3-1 - Stock - B4B	4 pcs	3/18/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
180	QC 21 - SA	4	3/18/19	0.00 0.00	QC 21 - SA - 21

DAS
40
9-89

APR 02 2019

5+402 80 APR 03 2019

DAS
21
9-89
APR 04 2019

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pcs		QC 21 - SA - 70	
		QC 21 - SA - 53	

Part Op **100** - HAAS CNC Vertical Machine Program batch number. 1- Inspect part number and batch number are programmed
 Descriptions: correctly. 2- Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet 3- Machine Step No 2 of
 Folio and visually inspect as per attached Dimension Sheet
110 - Manufacture as per dwg - Machine Keyway and inspect per attached dimension sheet
120 - QC2- Inspect parts off machine FAI/FAIB
130 - QC8- Inspect parts - second check
140 - Chemical Conversion Coat per QSI005 4.1
150 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum START TIME: _____ OVEN TEMPERATURE: _____
 FINISH TIME: _____
160 - QC 7 - Inspect Chemical conversion coat
170 - Identify as per dwg & Stock Location: _____
180 - QC21- Final Inspection - Work Order Release

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D6101-003	Saddle Billet, 7075	4 pcs (1 ea)	100-HAAS 4 Axis	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	D6101-003	4	47	0

Part Specifications	
Specifications could not be found.	

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D2665-1
Job Sheet 190710



Part No: D2665-1

Job Qty: 4 ea

Part Name: Saddle, LH Fwd Aft Out



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/13/19

Job Tracking No:

Due Date: 3/18/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV D IPP: C 00.11.01 Removed P/O for Powder Coat - in house process EC IPP Rev:D As per Rev D 07-03-19 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	3/18/19	3/18/19	0.00	0.00	Start Up Machining-1		
100	CNC Vertical Machining	4 pcs	3/18/19	3/18/19	1.75	6.15	HAAS1-2		
110	Mill Conv	4 pcs	3/18/19	3/18/19	0.00	4.00	Conv Mill 1		
120	QC	4 pcs	3/18/19	3/18/19	0.00	0.00	QC2 Machining-1		
130	QC	4 pcs	3/18/19	3/18/19	0.00	0.00	QC8 Machining-1		
140	HandFinish	4 pcs	3/18/19	3/18/19	0.00	0.28	HandFinish1		
150	Powdercoat	4 pcs	3/18/19	3/18/19	0.00	0.20	Powdercoat1		
160	QC	4 pcs	3/18/19	3/18/19	0.00	0.00	QC3		
170	Packaging	4 pcs	3/18/19	3/18/19	0.00	0.00	Packaging3-1		
180	QC21-SA	4 Ea	3/18/19	3/18/19	0.00	0.00	QC21		

Part Op 100 - Program batch number. 1- Inspect part number and batch number are programmed correctly. 2- Machine Step No 1 Descriptions: of Folio and visually inspect as per attached Dimension Sheet 3- Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet

110 - Machine Keyway and inspect per attached dimension sheet

150 - START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-003	Saddle Billet, 7075	4 pcs (1 ea)	90-Start up Operation	5156345 x4

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-003	4	47	0

Part Specifications

Specifications could not be found.

Plex 2/13/19 2:31 PM Dart.lajeunesse.marie

DART AEROSPACE LTD				Work Order: 190710	
Description: 206 Saddle, Outboard, Left side				Part Number: D2665-1	
Inspection Dwg: D2665 Rev: D DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		0.121	0.120	0.120	0.120	
B	0.100	0.140		0.129	0.128	0.128	0.130	
C	1.125	1.145	/	1.135	1.135	1.135	1.135	
D	0.615	0.685	/	0.645	0.645	0.645	0.645	
E	0.240	0.260		0.250	0.252	0.253	0.252	
F	1.313	1.343	/	1.323	1.325	1.323	1.323	
G	0.210	0.230		0.222	0.223	0.2215	0.223	
H	0.100	0.180	/	0.130	0.130	0.130	0.130	
I	2.470	2.510	/	2.500	2.500	2.500	2.500	
J	1.565	1.585	/	1.573	1.573	1.573	1.573	
K	0.235	0.240		0.239	0.239	0.237	0.238	
L	0.100	0.120		0.110	0.109	0.108	0.109	
M	0.990	1.010	/	0.999	0.999	0.999	0.999	
N	0.510	0.515	/	0.511	0.511	0.511	0.511	
O	5.990	6.010		5.994	5.996	5.997	5.997	
P	1.245	1.255	/	1.250	1.250	1.250	1.250	
Q	2.495	2.505	/	2.500	2.500	2.500	2.500	
R	0.312	0.318	/	0.312	0.312	0.312	0.312	
S	0.315	0.322	/	0.316	0.316	0.316	0.316	
T	2.495	2.505	/	2.500	2.500	2.500	2.500	
U	1.357	1.367	/	1.362	1.362	1.362	1.362	
V	0.787	0.807		0.795	0.793	0.7925	0.794	
W	0.540	0.560		0.546	0.554	0.5492	0.550	
X	1.674	1.684	/	1.679	1.679	1.679	1.679	
Y	0.256	0.262	/	0.257	0.257	0.257	0.257	
Z	0.912	0.932		0.920	0.926	0.924	0.925	
AA	0.490	0.510		0.494	0.492	0.49625	0.497	
AB	0.178	0.198	/	0.188	0.188	0.188	0.188	
AC								
AD								
AE								
Accept/Reject								

Measured by: VHS	Date: 19/3/29
Audited by: 19/3/29 JML	Date: 19/03/31
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.03.08	Dimension R and Y revised	KJ	M

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					